

Work Order ID 69210

Page 1

Wednesday, May 04, 2011 4:19:45 PM

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 5/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: 115928

6/11/05/10

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

BE
6/11/05/10

1 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

0.00

Memo

8 1/2 hrs

125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

Memo

IX ~~Ø~~ Mr. Lufos/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|----------------|---------------------|------------|------|-------|---------------|--|
| Item ID: | D2989-043 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Basket Lid Assembly | | | | | |
| Start Date: | 5/4/2011 | Start Qty: | 1.00 | | Cust Item ID: | |
| Required Date: | 5/10/2011 | Req'd Qty: | 1.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 130 | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|



Powdercoat

Powder Coating

Memo

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00 OF
4:00
1:30

(IX) ~~0~~ m/ 11/05/11

M 116964

| | | | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|
| 140 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|



QC

Quality Control

Memo

1 ~~0~~ m/ 11/05/12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Setup Start



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Item Name: Basket Lid Assembly

Start Date: 5/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

*W/O
69207*

0.00

Packaging

ES 4/05/12 @

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*ck 4/05/16
mf
11-5-13*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 04, 2011 4:19:52 PM

Page 1

Work Order ID: 69210

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly




Start Date: 5/4/2011

Required Date: 5/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2221-1  Rib | | Manufactured | No | | | 100 | Each | 14.0000 | 1 | 1 | | Pl 11.05.10 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA006 | | 14 | | | | | | | |
| | | | | 67350 | | 2 | | | | | | | |
| | | | | 67465 | | 12 | | | | | | | |
| D2989-3  Rib | | Manufactured | No | | | 100 | Each | 2.0000 | 1 | 1 | | Pl 11.05.10 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA | | 1 | | | | | | | |
| | | | | 67424 | | 1 | | | | | | | |
| | | | | WA005 | | 1 | | | | | | | |
| | | | | 66917 | | 1 | | | | | | | |
| D2989-4  Rib | | Manufactured | No | | | 100 | Each | 2.0000 | 1 | 1 | | Pl 11.05.10 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA | | 1 | | | | | | | |
| | | | | 67423 | | 1 | | | | | | | |
| | | | | WA005 | | 1 | | | | | | | |
| | | | | 66916 | | 1 | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 04, 2011 4:19:52 PM

Page 2

Work Order ID: 69210

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 5/4/2011

Required Date: 5/10/2011

Start Qty: 1.00

Required Qty: 1.00

D2989-5

Manufactured No

100 Each

2.0000

2

2



Rib



PL 11.05.10

Location

Loc Qty

Loc Code

WA

2

67425

2

D3182-1

Manufactured No

100 Each

4.0000

2

2



Hinge



PL 11.05.10

Location

Loc Qty

Loc Code

WA005

4

65486

2

67347

2

D3442-3

Manufactured No

100 Each

9.0000

2

2



Shim



PL 11.05.10

Location

Loc Qty

Loc Code

WA

4

67426

4

WA005

5

66912

5

D3827-041

Manufactured No

100 Each

5.0000

1

1



Rib Assembly (Inboard)



PL 11.05.10

Location

Loc Qty

Loc Code

WA006

5

67275

5

Wednesday, May 04, 2011 4:19:53 PM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 04, 2011 4:19:53 PM

Page 3

Work Order ID: 69210



Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 5/4/2011

Required Date: 5/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3832-5 Manufactured No

100 Each

3.0000

1

1



Mesh (Lid)



Pl 11.05.10

Location

Loc Qty

Loc Code

WA

3

67494

3

D3833-5 Manufactured No

100 Each

0.0000

2

2



Mesh (Lid End)



364946 → ② Pl 11.05.10

D3838-041 Manufactured No

100 Each

0.0000

1

1



Rib Assembly (Basket Lid, LH)



367427 → ① Pl 11.05.10

D3838-042 Manufactured No

100 Each

0.0000

1

1



Rib Assembly (Basket Lid, RH)



368477 → ① Pl 11.05.10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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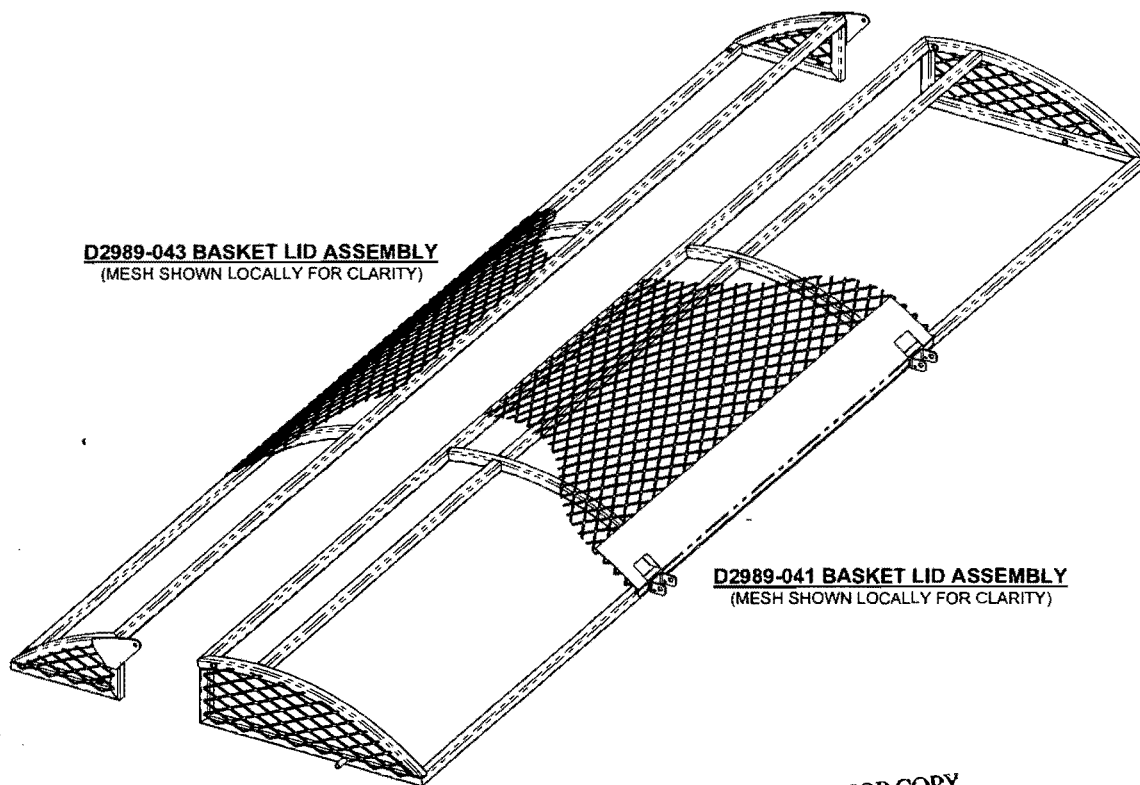
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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69210

RD11-05.4

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|---------------------------|
| 1 | X | | D2989-041 | BASKET LID ASSEMBLY |
| 2 | | X | D2989-043 | BASKET LID ASSEMBLY |
| 3 | 1 | | D2506 | LABEL PLATE |
| 4 | 1 | | D2512-7 | RIB |
| 5 | 2 | | D2581 | MOUNTING BRACKET |
| 6 | | 1 | D2989-3 | RIB |
| 7 | | 1 | D2989-4 | RIB |
| 8 | | 2 | D2989-5 | RIB |
| 9 | 2 | | D2989-13 | RIB |
| 10 | 2 | 1 | D2989-17 | RIB |
| 11 | 2 | | D2989-19 | RIB |
| 12 | | 2 | D3182-1 | HINGE |
| 13 | | 2 | D3442-3 | SHIM |
| 14 | | 1 | D3827-041 | RIB ASSY (INBOARD) |
| 15 | 1 | | D3832-3 | MESH, BASKET LID |
| 16 | | 1 | D3832-5 | MESH, BASKET LID |
| 17 | 2 | | D3833-3 | MESH, LID END |
| 18 | | 2 | D3833-5 | MESH, LID END |
| 19 | 1 | | D3836-041 | RIB ASSY (BASKET LID, LH) |
| 20 | 1 | | D3836-042 | RIB ASSY (BASKET LID, RH) |
| 21 | | 1 | D3838-041 | RIB ASSY (BASKET LID, LH) |
| 22 | | 1 | D3838-042 | RIB ASSY (BASKET LID, RH) |
| 23 | 1 | | D3852-041 | RIB ASSEMBLY |
| 24 | 1 | | D3852-042 | RIB ASSEMBLY |

RELEASED
08/11/10

| | | | |
|------------|--|--|--------------|
| D | REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3836-041 REPLACES D2989-1/-7; D3836-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM | MB | 08.09.24 |
| C | FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD | AJS | 08.06.20 |
| B | ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS | PH | 05.06.07 |
| A | NEW ISSUE | DS | 00.10.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | | DRAWING NO. | REV. D |
| CHECKED | <i>AJS</i> | D2989 | SHEET 1 OF 5 |
| MFG. APPR. | <i>AJS</i> | TITLE | SCALE |
| APPROVED | <i>AJS</i> | BASKET LID ASSEMBLY | NTS |
| DE APPR. | <i>AJS</i> | COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATIONS IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 08.09.24 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

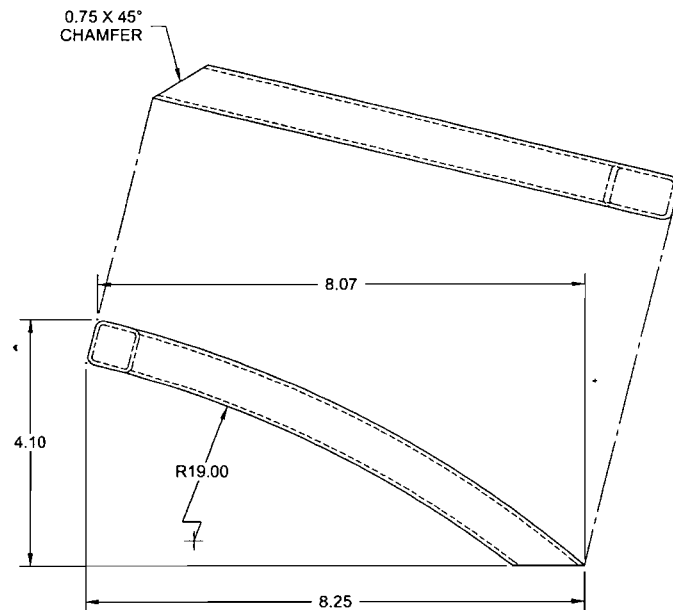
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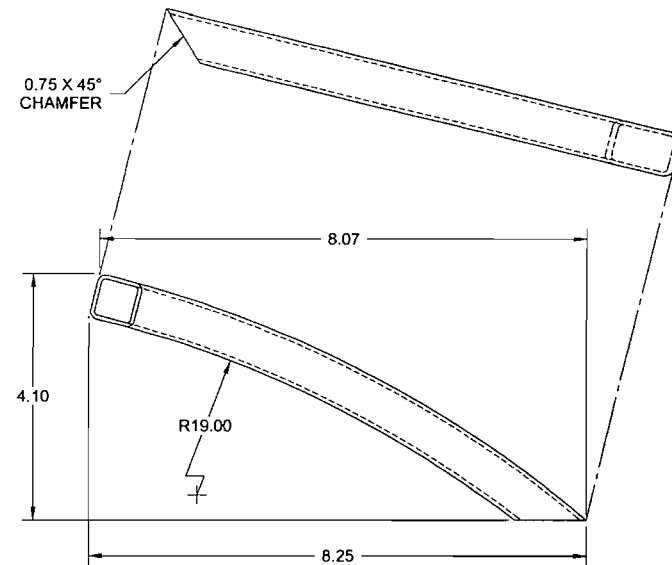
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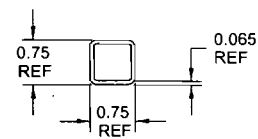


D2989-3 RIB



D2989-4 RIB

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



TYPICAL SECTION VIEW

RELEASED
08/11/18 NW

| | | | |
|------------|----------|---|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D2989 | SHEET 4 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY | NTS |
| DATE | 08.09.24 | <small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

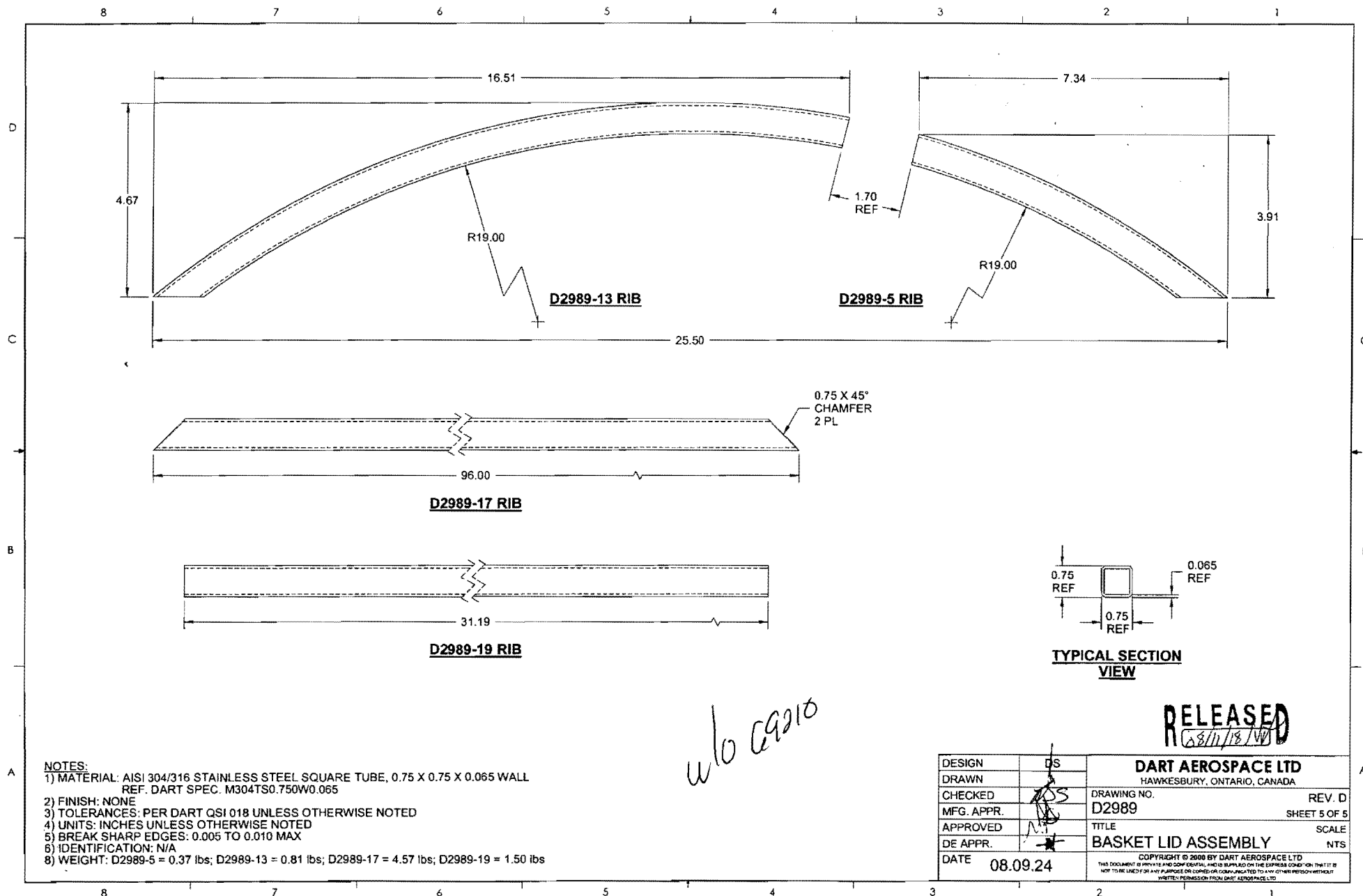
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
03/11/18

| | | | |
|---|----------|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | DS | DRAWING NO. | REV. 1 |
| MFG. APPR. | | D2989 | SHEET 5 OF 5 |
| APPROVED | | TITLE | SCALE |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries